

Work Order ID 86475-

June-29-12 1:30:11 PM

Split
86475

Page 1

Item ID: D4545-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MCS*

Date: *12/06/29* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4545

C

100

Pick Kit

0.00

1000

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- DISASSEMBLE AND DEBURR

3- DIMPLE HOLES AS PER DWG

10
10
12/07/29
12/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86475

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Page 2

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Stop *NS2*

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Start Date: 29/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

SmB
12-8-31

DA
16

12/08/31

41

4X Ø

M-L
12/08/31

4 φ

B# 12-8-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 86475

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Page 3

Item ID: D4545-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Retainer, Inner, LH (Lower)

Stop ***NS2***

Start Date: 29/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

145

Small Fab

Memo

0.00

0.00

Small Fab

INSTALL NUT PLATES AND ASSEMBLE AS PER DWG

4X

[Signature]
12/08/12

147

147

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Smb
12-8-31

DAS
16
2-3

12/02/12

4X

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: ST 157x 0.00

Memo

0.00

4X

SP
12-8-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			SAO 31 4-1					

NOTE: Date & initial all entries

Work Order ID 86475

86475

Page 4

June-29-12 1:30:11 PM

Item ID: D4545-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, Inner, LH (Lower)
 Start Date: 29/06/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 13/07/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/9/59
 ME
 12-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-29-12 1:30:14 PM

Page 1

Work Order ID: 86475

86475

Parent Item: D4545-041

D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A 12.01.13 new issue DD verf:JLM
12.02.27 AS PER DWG REV.B DD VERF:EC
as per dwg revC DD verf:EC

IPP REV:B
IPP REV:C 12.05.08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4541-1
D4541-1
Bracket

Manufactured No

100

Each

7.0000

1

10

**

Location

Loc Qty

Loc Code

FG

3

B 86460
B 87775

78764

3

GA

4

81260

2

84957

2

D4542-1
D4542-1
Retainer, Inner, lh

Manufactured No

100

Each

5.0000

1

10

**

Location

Loc Qty

Loc Code

GA

5

81265

5

MS20426AD3-4

Purchased No

145

Each

2,750.000

40

400

**

MS20426AD3-4
RIVET

Location

Loc Qty

Loc Code

ST316

2750

104374

236

110398

2514

10 9/12/08/31

9/12/08/31
388074 4x

9/12/08/31
160

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-29-12 1:30:14 PM

Page 2

Work Order ID: 86475

86475

Parent Item: D4545-041

D4545-041

Parent Item Name: Retainer, Inner, LH (Lower)

Start Date: 29/06/2012

Required Date: 13/07/2012

Start Qty: 10.00

Required Qty: 10.00

MS21059L3K

Purchased

No

145

Each

206.0000

19

190

MS21059L 3K

Nutplate

**

Location

Loc Qty

Loc Code

ST302

206

121114

206

MS21061L3K

Purchased

No

145

Each

45.0000

1

10

MS21061L 3K

NUT PLATE

**

Location

Loc Qty

Loc Code

ST303

45

120242

45

Handwritten:
 EPB 2/08/31
 M122452 (76)
 EPB 2/08/31
 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

WORK COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 86475 MCT
 12/04/29

RELEASED
 2012-05-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

C	CHG FINISH (ZN AB-1); D4541-5F WAS -5 (C4-1)	CP	12.04.20
B	ADD FINISH (ZN AB-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. C SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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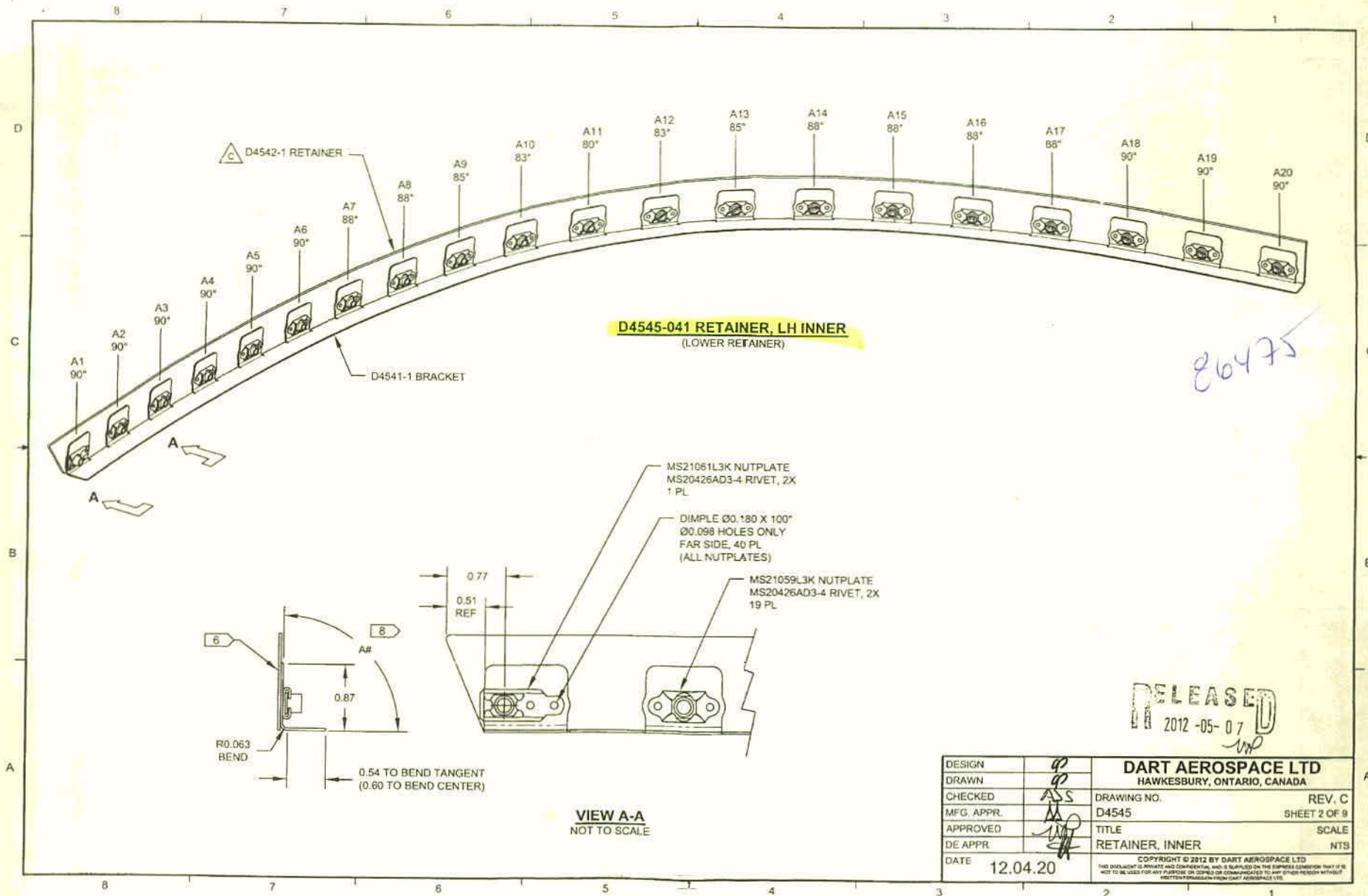
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2012-05-07
WIP

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DRAWN	JP		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	WIP	D4545	SHEET 2 OF 9
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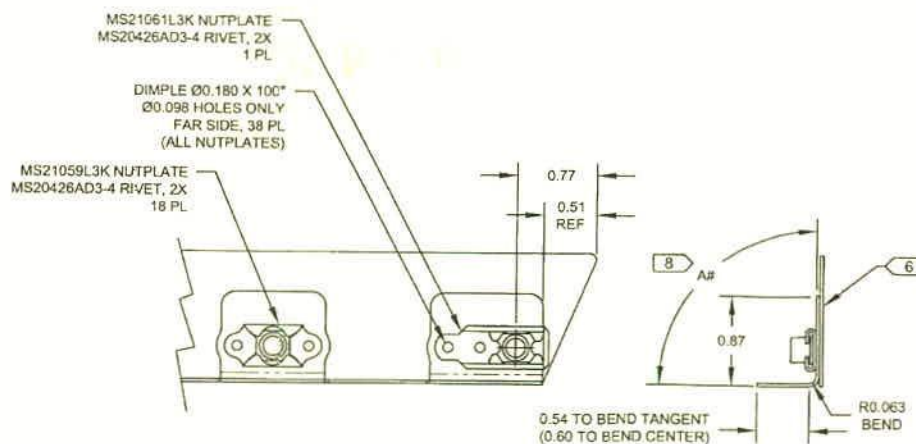
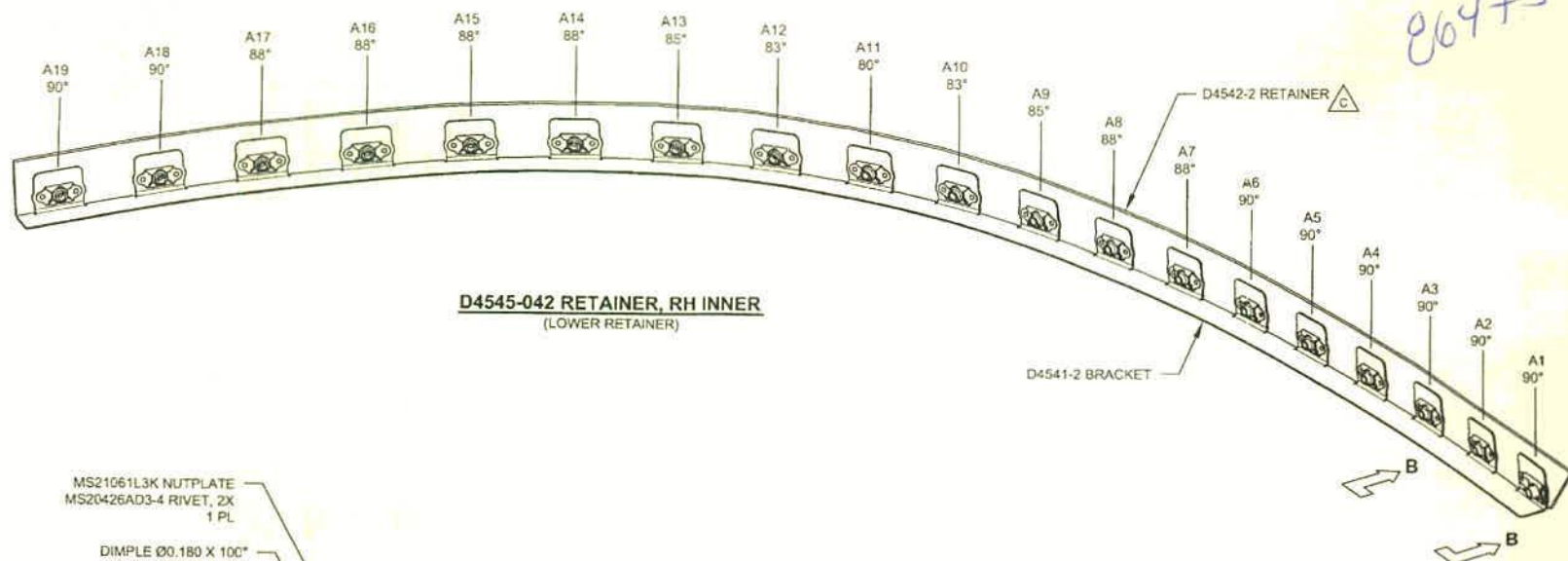
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW B-B
NOT TO SCALE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 3 OF 9
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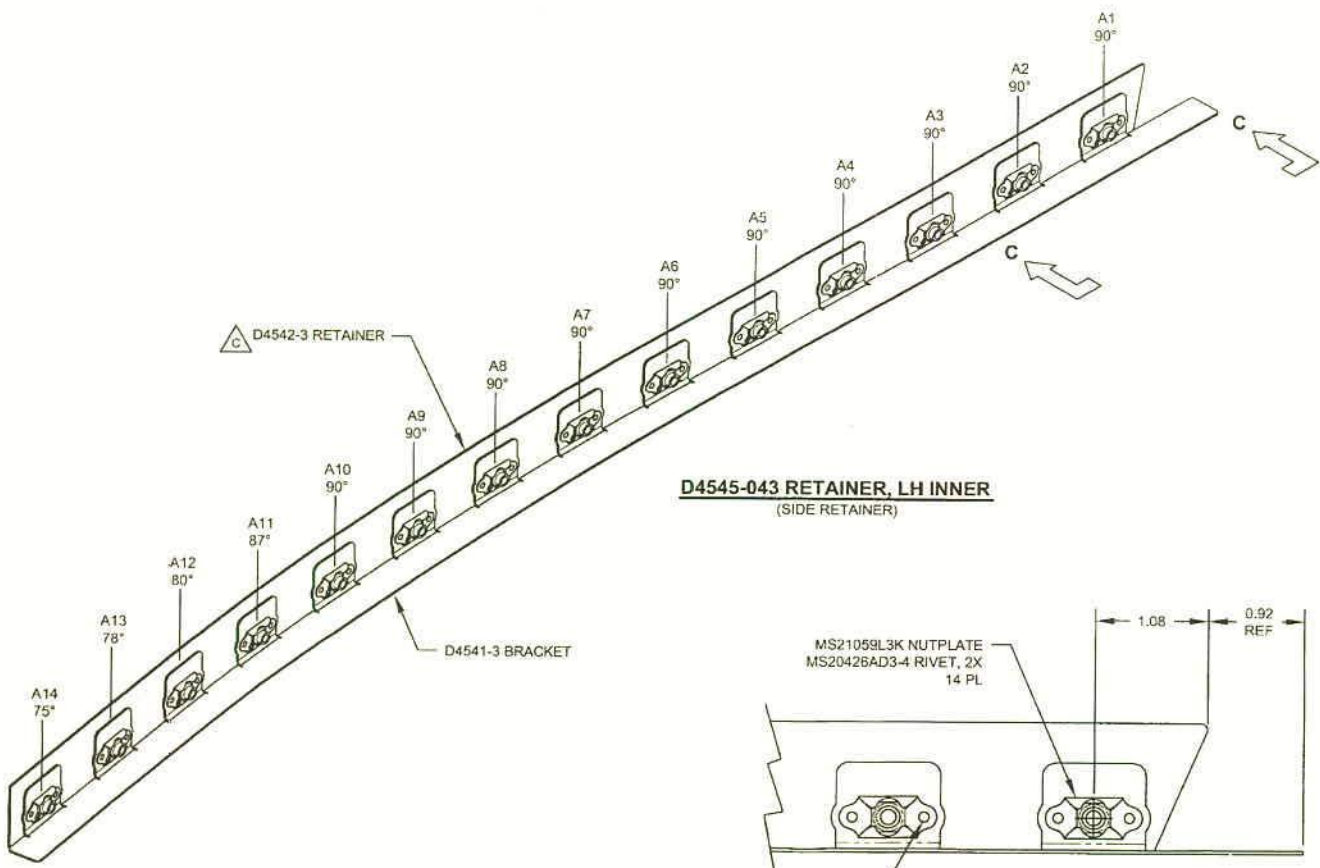
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

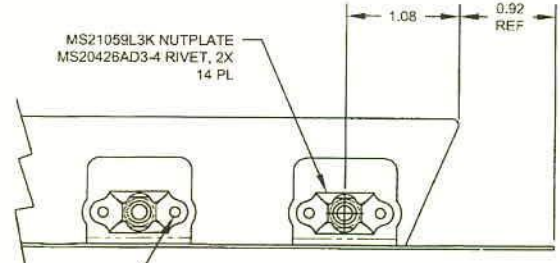
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

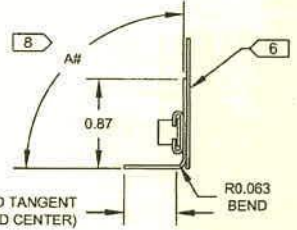
NOTE: Date & initial all entries



D4545-043 RETAINER, LH INNER
(SIDE RETAINER)



VIEW C-C
NOT TO SCALE



DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	MP	D4545	SHEET 4 OF 9
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2012-05-07

W/O:		WORK ORDER CHANGES					
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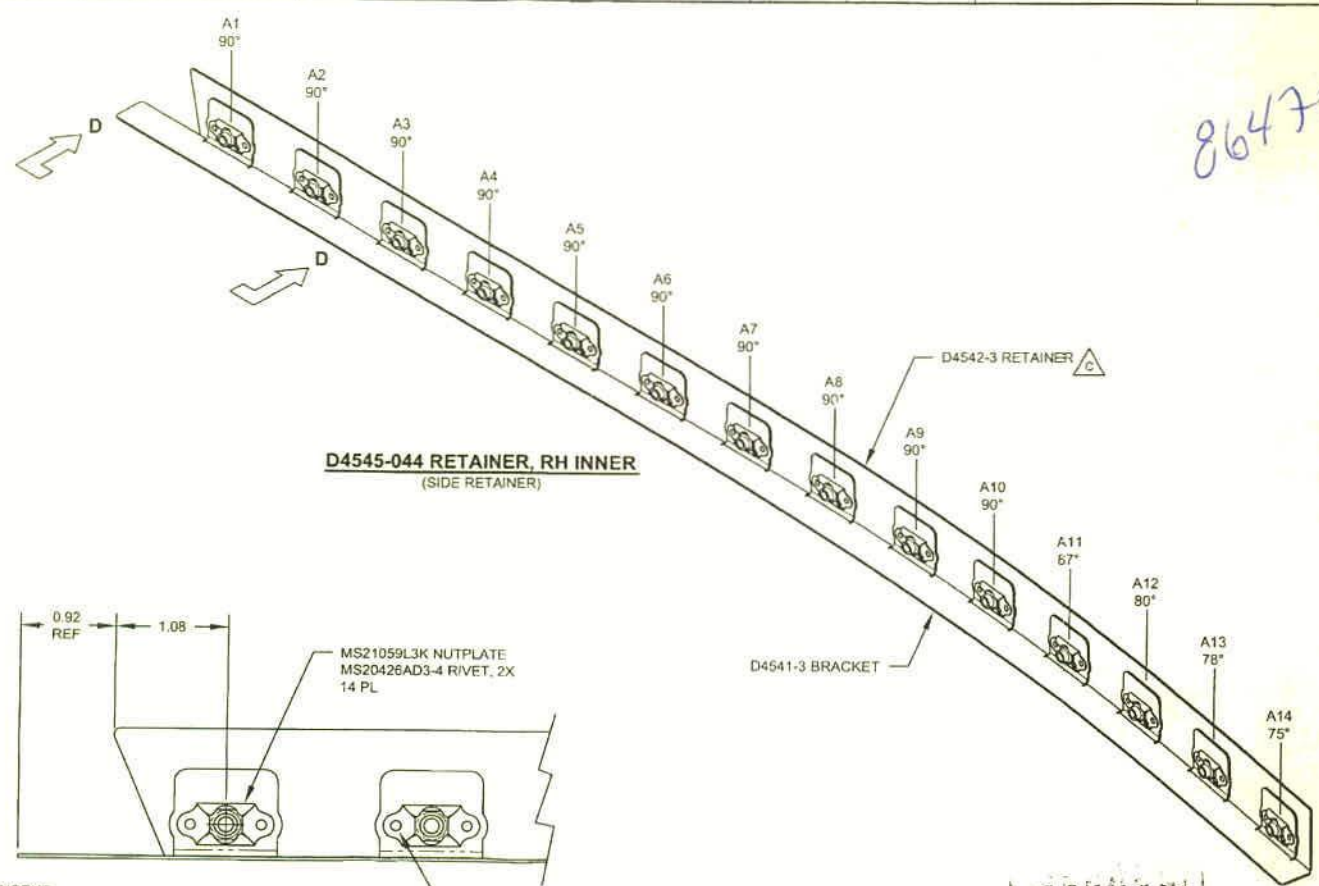
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

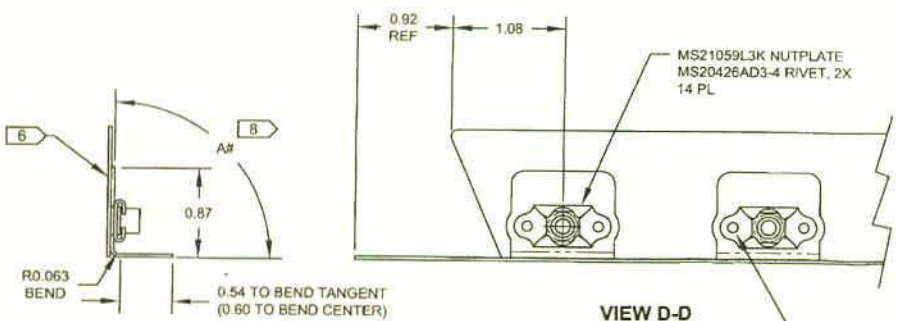
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NOTE: Date & initial all entries

86475



D4545-044 RETAINER, RH INNER
(SIDE RETAINER)



VIEW D-D
NOT TO SCALE

DIMPLE Ø0.188 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 FL

2012-05-03

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	D4545	SHEET 5 OF 9
APPROVED	MF	TITLE	SCALE
DE APPR.	MF	RETAINER, INNER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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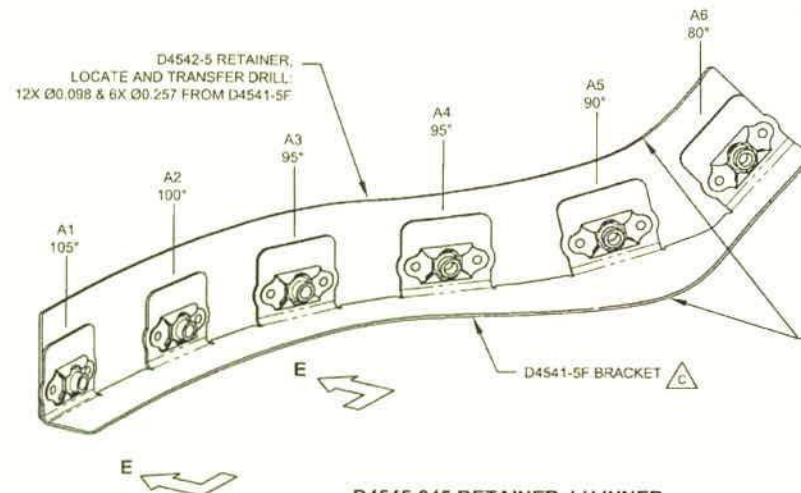
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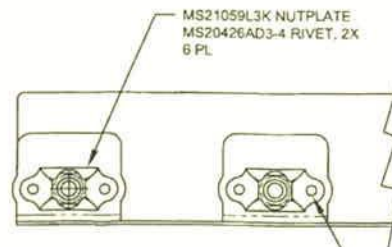
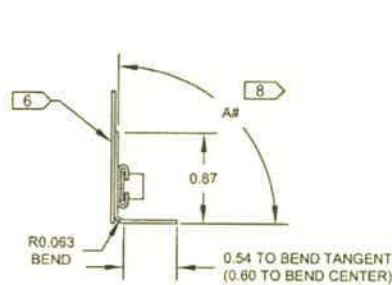
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NOTE: Date & initial all entries

26475



D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



VIEW E-E
NOT TO SCALE

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D4545	REV. C
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2012-05-07

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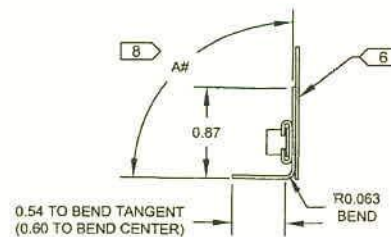
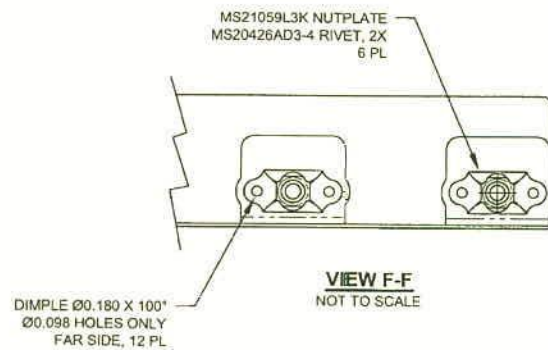
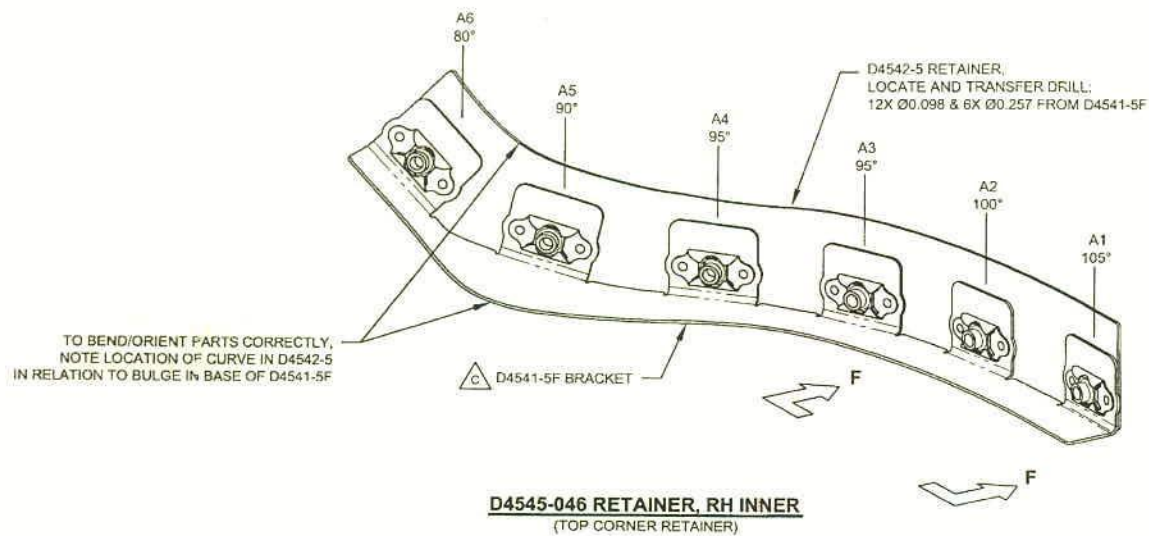
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RELEASED
2012-05-07

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	MP	D4545	SHEET 7 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RETAINER, INNER	NTS
DATE	12.04.20	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR LINES OR CONSIDERED TO BE ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

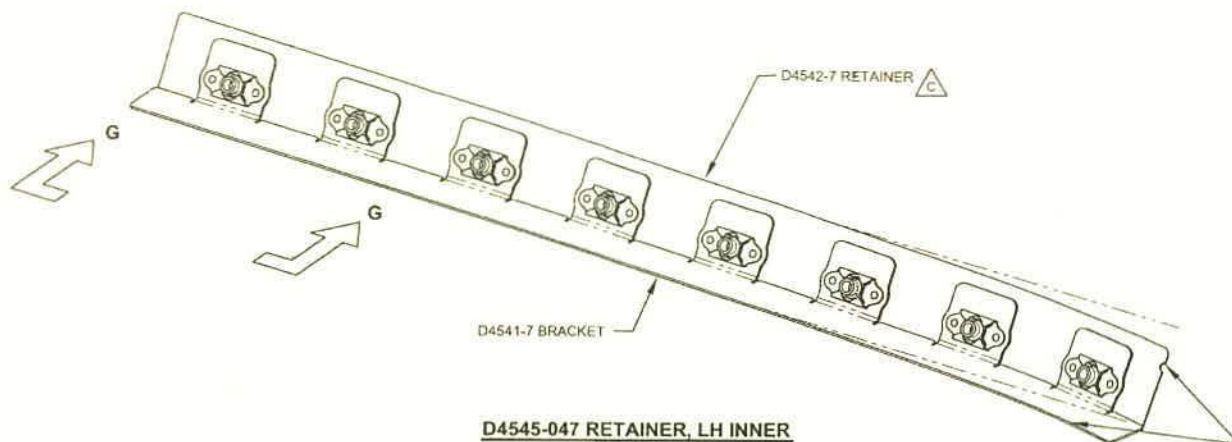
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

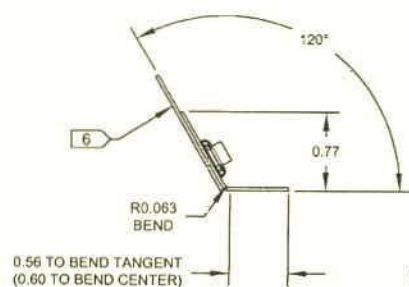
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

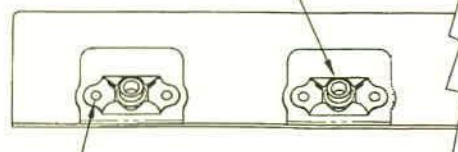


D4545-047 RETAINER, LH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7.



MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW G-G
NOT TO SCALE

RELEASED
2012-05-08

DESIGN	40	DART AEROSPACE LTD	
DRAWN	40	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D4545	REV. C
MFG. APPR.			SHEET 6 OF 9
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

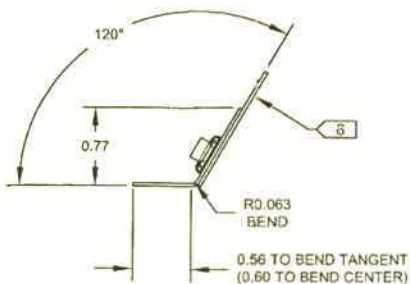
NOTE: Date & initial all entries

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100"
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



D4545-048 RETAINER, RH INNER
(TOP RETAINER)

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	AD	D4545	SHEET 8 OF 9
APPROVED	AD	TITLE	SCALE
DE APPR	AD	RETAINER, INNER	NTS
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86475

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries